

Work Order ID 135485

Wednesday, August 12, 2015 4:30:39 PM

135485

Page 1

Item ID: D4925-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Plate Assembly
Start Date: 8/12/15 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 8/12/15 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MLJ Date: AUG 14 2015 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4925	D

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet nutplate to D4925-1 as per dwg.

2 FF SEP 21 2015

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

(2) DAS 38 9-00 SEP 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Powdercoat Powder Coating	Gloss Black (Alum) (Ref:QSI005 4.3.5.13) Small Fab Memo ***Insert screw BY HAND in nutplate prior to powdercoating*** START TIME: 11:00 OVEN TEMPERATURE: 320 FINISH TIME: 11:30	0.00 0.00							2 15-9-21. DAS 34 9-89
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							(2) DAS 38 9-89 SEP 21 2015
135 *135* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							(2) DAS 38 9-89 SEP 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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 Item Name: Mounting Plate Assembly
 Start Date: 8/12/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCK D10</u>	0.00				<u>Z</u>			
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

Z DAS 6 9-89 SEP 21 2015

ML5 SEP 21 2015

SU 20150921

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Wednesday, August 12, 2015 4:30:39 PM

Page 1

Work Order ID: 135485

135485

Parent Item: D4925-041

D4925-041

Parent Item Name: Mounting Plate Assembly

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.10.01 new issue DD verf:JLM IPP REV:B
14.01.13 AS PER DWG REV.A DD VERF:JLM IPP REV:C 15.06.17
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4925-1 *D4925-1* EAPS Mounting Plate		Manufactured	No			100	Each	0.0000	1	2			
LN29985-A05 *LN29985-A05* Anchor Nut		Purchased	No			100	Each	0.0000	6	12			
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			100	Each	3,691.000	12	24			

**

**

**

B135487

m133062 SP

FF

SEP 21 2015

Location

Loc Qty

Loc Code

CA

12

125578

12

GA

3293

m131697

3293

MF4

7

125578

7

ST313

379

m127432

379

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

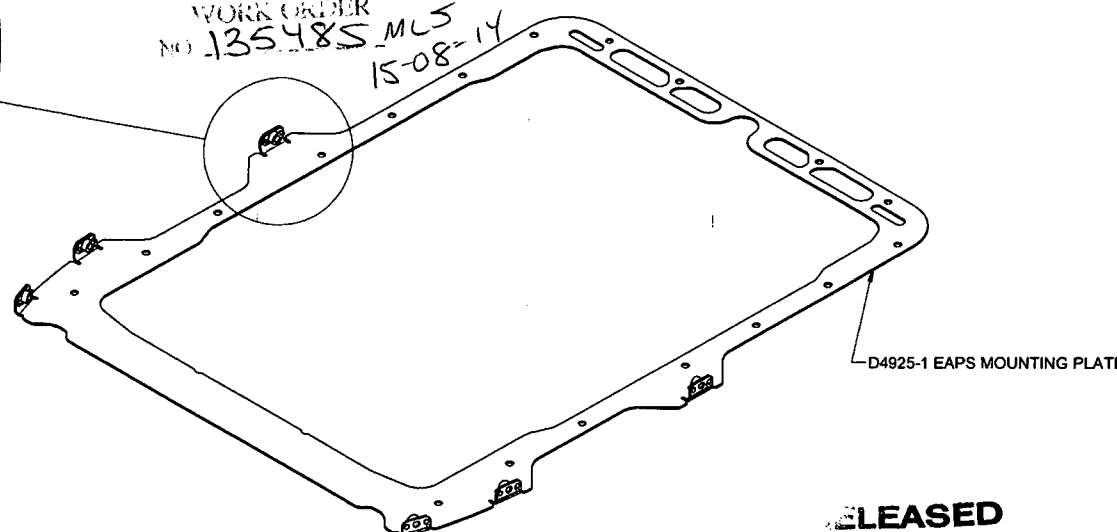
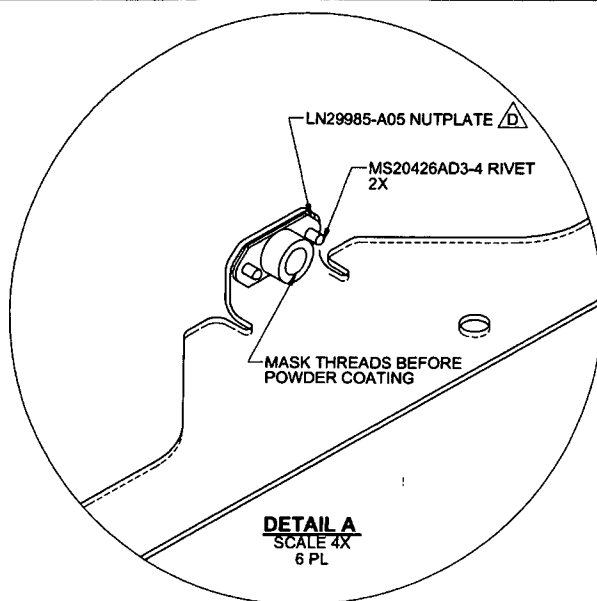
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4925-041	EAPS MOUNTING PLATE ASSY
1	1	D4925-1	EAPS MOUNTING PLATE
2	6	LN29985-A05	NUTPLATE (LN29985-AM5)
3	12	MS20426AD3-4	RIVET, CSK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 135485_MCS
15-08-14



D4925-041 EAPS MOUNTING PLATE ASSY

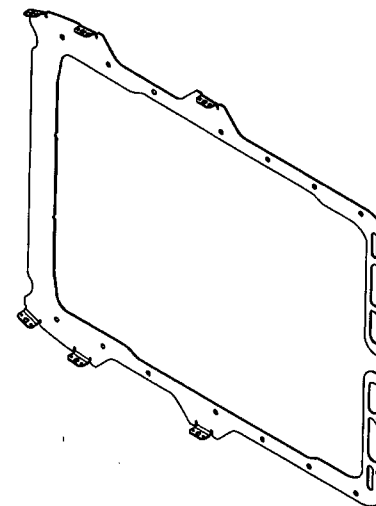
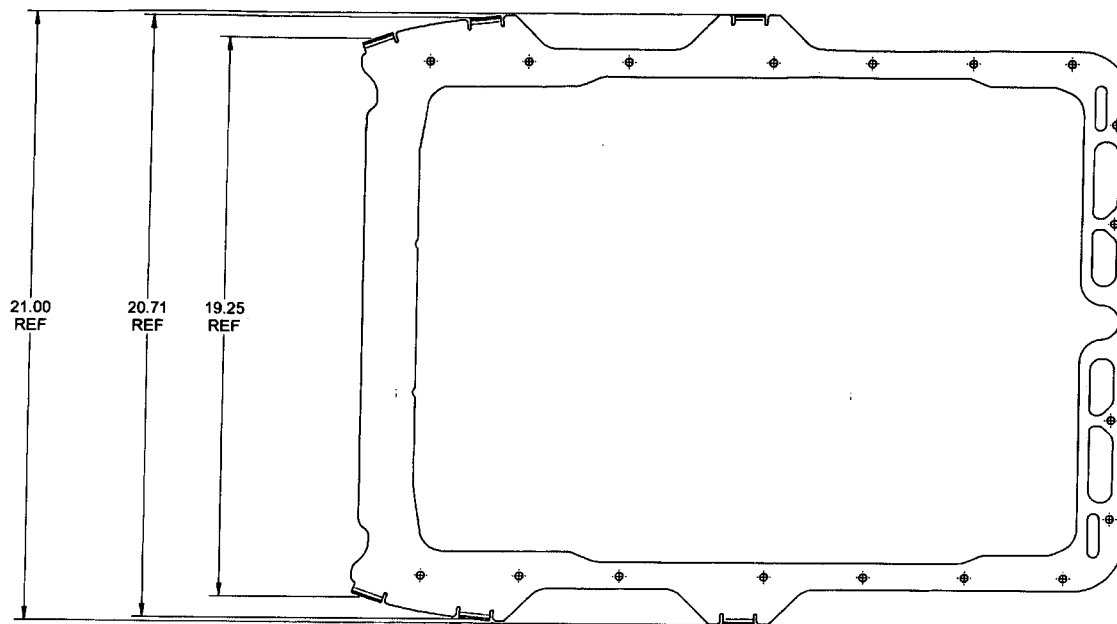
RELEASED
2015 JUN 16
ECN 15-527

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4925-041" PER QSI 044 6.1
 - 7) WEIGHT: 0.27 LBS

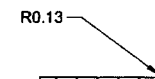
D	UPDATED BOM (LN29985-A05 WAS MS21059L3), REVISED DETAIL C: ZN B2-3	AK	15.03.06
C	REMOVE SLOTS (5 PL) AND EDGE SCALLOP DETAIL	DB	14.04.04
B	COMPLETE RE-DESIGN, SEE REV A FOR DETAILS	DB	14.01.15
A	NEW ISSUE	DB	13.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE	15.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1



D4925-1 EAPS MOUNTING PLATE
(MAKE FROM D4925-1F)



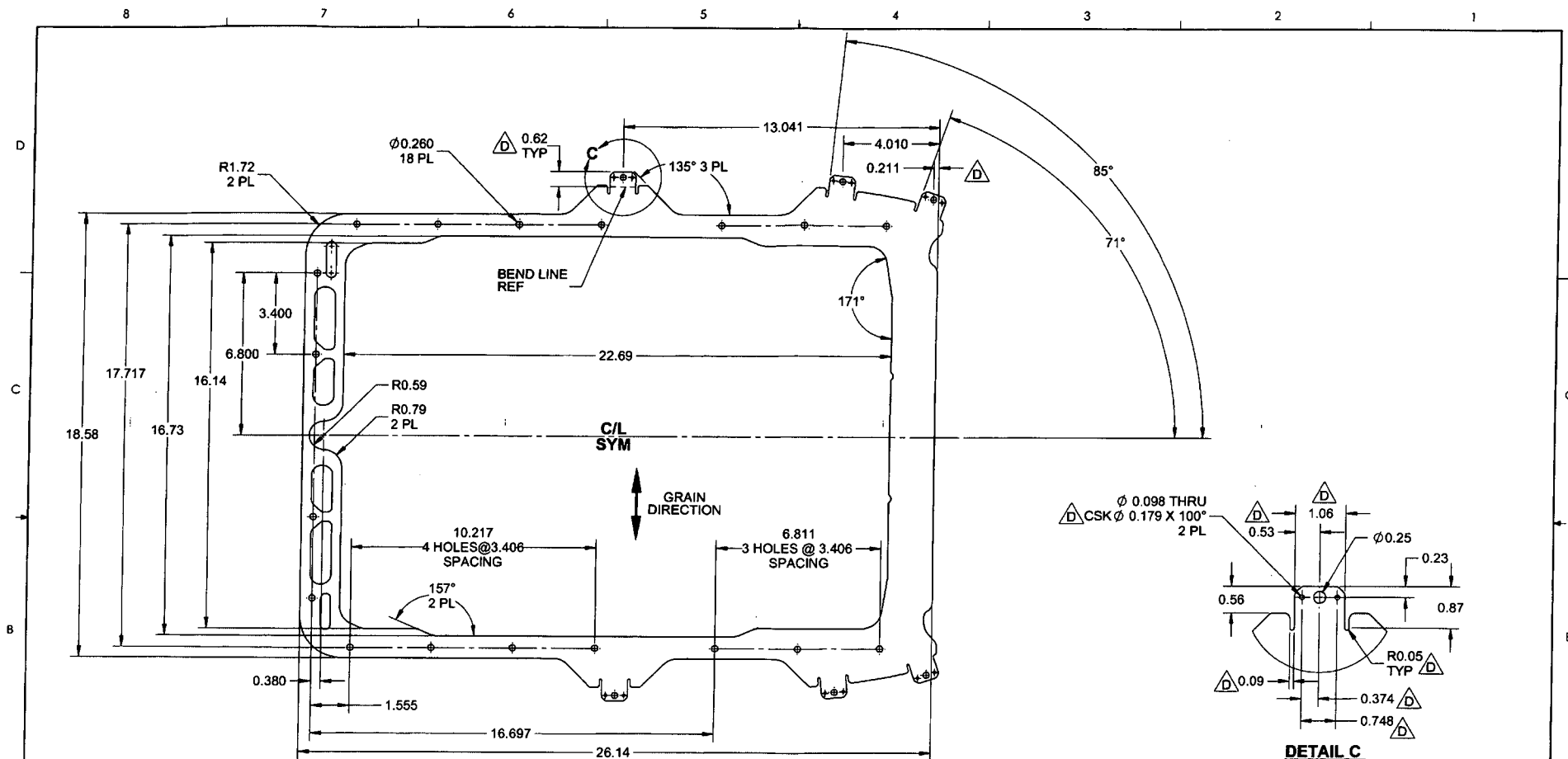
SECTION B-B
SCALE 2X

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2015 JUN 16

- NOTES:
- 1) MATERIAL: MAKE FROM D4925-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

APPROVED

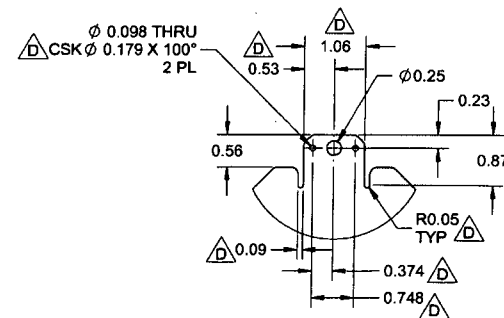
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
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D4925-1F EAPS MOUNTING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 0.063 THICK
REF DART SPEC M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT 0.26 LBS
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4925-1F Rev D.DXF".



DETAIL C
SCALE 2X
6 PL

RELEASED

2015 JUN 16

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DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
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